

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005851**Date Inspected:** 02-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2030**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/2/09, Caltrans OSM Quality Assurance (QA) Inspector Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in either the Fabrication shop #4 and/or Foundry Shop at Japan Steel Works.

Reviewed QC CWI Mr Chung Fu Kuan's daily reports covering 3/31 through 4/2/09 all data appears accurate and complete.

W2E3 - Casting awaiting fit-up to built up section, built up section bevel preparation appears complete.

W2W2 - QC NDE technician Mr H. Kohama was in process of conducting Wet Magnetic Particle testing of casted/shaped/blasted Level 1 areas.

W2W3 - Casting is in process of Post Weld Heat Treat following repair welding.

T1-3 - Buttering procedure SJ3012-1-1 was used by welders D. Hirakawa 08-3566, H. Narita 08-5092, T. Kawagishi 08-5026, and T. Mitsui 07-4428, on joints 9Y-10U (1st layer), 9Y-8U (1st layer), 9Y-5U-1 (1st layer) and 9Y-11U (1st layer) respectively, all parameters set forth appeared to be met at this time.

E2E1 - Two men actively shaping, by way of Carbon Arc.

E2W1 - Two men actively grinding, 90% complete.

**West Jacking Saddle**

- Verified condition of saddle located in Laydown yard adjacent pier.

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## WELDING INSPECTION REPORT

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Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No significant conversations to report on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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